

Work Order ID 65292

January 11, 2011 9:16:37 AM



Page 1

Item ID: D3282-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Float Web (206L/407)

Start Date: 1/11/11 Start Qty: 6.00



Cust Item ID:

Required Date: 1/21/11 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3282	Rev C								

100

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut to length as per Dwg D3282.
2- inspect for surface damage as per QSI0018
3- Deburr

6

BB

11/01/12

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA579 & Dwg D3282
2-Deburr

aml 11/01/14

6

6

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

aml 11/01/18

6

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Start Date: 1/11/11 Start Qty: 6.00



Cust Item ID:

Required Date: 1/21/11 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC8- Inspect parts - second check

0.00

SL 11/01/19

QC Memo

0.00

Quality Control

140 Chemical Conversion Coat per QSI005 4.1

0.00

DA

11-1-19

6

HandFinish Memo

0.00

Hand Finishing

150 QC3- Inspect Part Finish

0.00

QC Memo

0.00

Quality Control

6 8 BE 11-01-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date: 1/11/11 Start Qty: 6.00



Cust Item ID:

Required Date: 1/21/11 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web
A/RN/ALPS-3 M116551

11-1-19

170

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

11/1/20

180

0.00

Identify as per dwg & Stock Location: 46

Packaging

Memo

0.00

Packaging

11-1-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65292

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Page 4

Item ID: D3282-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Float Web (206L/407)

Start Date: 1/11/11 Start Qty: 6.00



Cust Item ID:

Required Date: 1/21/11 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/01/24

MF

11-01-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January 11, 2011 9:16:37 AM

Page 1

Work Order ID: 65292

Parent Item: D3282-041

Parent Item Name: Float Web (206L/407)



Start Date: 1/11/11

Required Date: 1/21/11

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:B 05.09.23 Procedure change KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MS20470AD4-7

Purchased

No

100

Each

2,292.000

57

342



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST320

2292

115996

992

116081

1300

343

DP 11-1-19

D2792-130

Manufactured

No

160

Each

48.0000

1

6



EXTRUSION

Location

Loc Qty

Loc Code

MAT06

48

61630

48

6

BB 11/01/12

D3283-1

Manufactured

No

160

Each

33.0000

2

12



Doubler

Location

Loc Qty

Loc Code

ST046

31

62966

15

63572

16

ST048

2

57725

2

12

DP 11-1-19

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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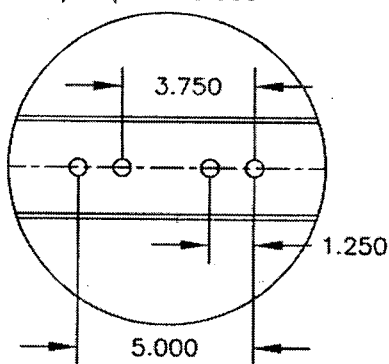
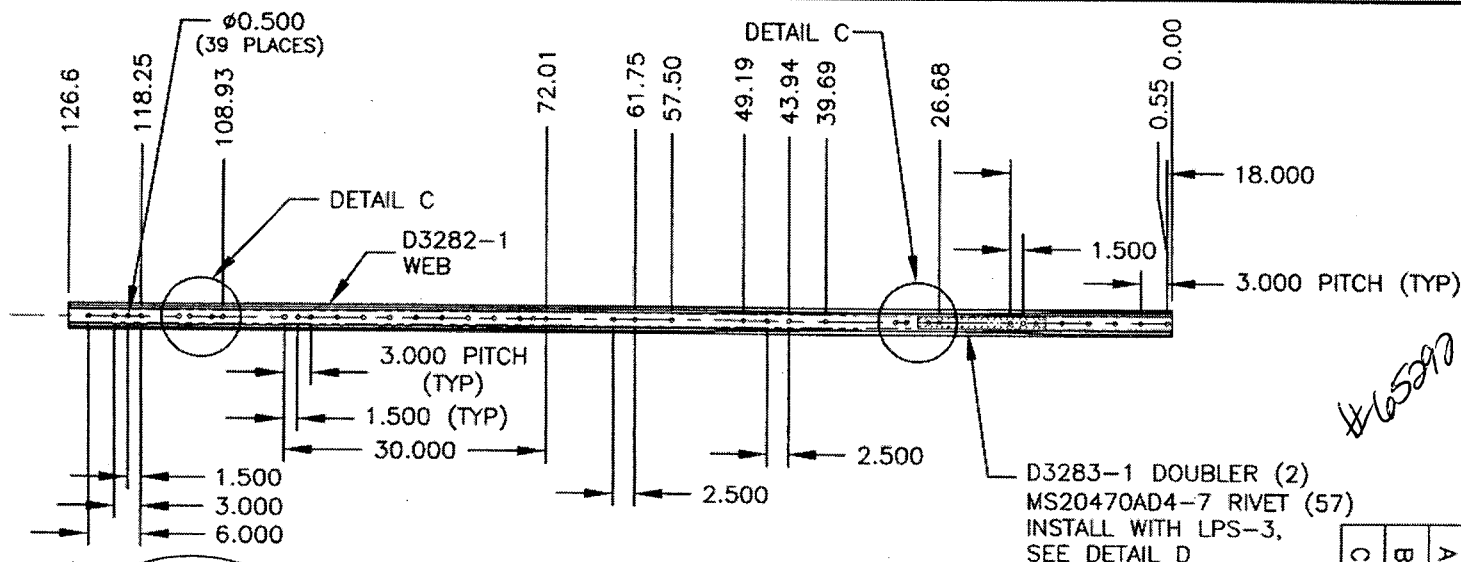
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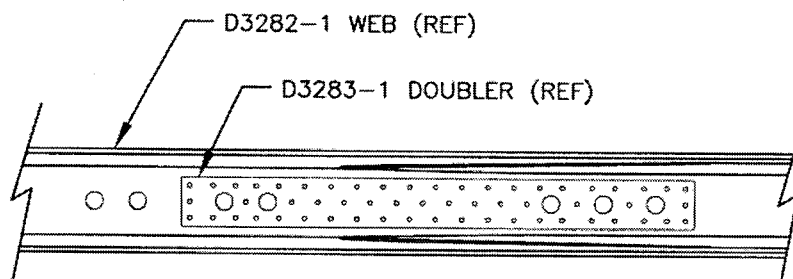
DART

865298

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. C
CP	CP	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 2
<i>[Signature]</i>	<i>[Signature]</i>	D3282	
DATE		TITLE	SCALE
05.08.09		FLOAT WEB, 206L/407	1:20
A	04.05.05	NEW ISSUE	
B	05.03.16	MOVE HOLES, ADD D3390-1 DOUBLERS	
C	05.08.09	REMOVE D3390-1, NOW MACHINED	



DETAIL C
SCALE 1:5
RIVET HOLES NOT SHOWN
FOR CLARITY



DETAIL D
SCALE 1:5

RELEASED
05.09.12

D3282-041 FLOAT WEB

- 1) MAKE FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-1 DOUBLERS AND D3282-1 WEB. INSTALL RIVETS COATED WITH LPS-3
- 6) SEE PAGE 2 FOR MACHINING DETAILS

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED	#	APPROVED	#	PORT HADLOCK, WA
DATE	05.08.09	TITLE	D3282	REV. C
		SCALE	1:20	SHEET 2 OF 2
				FLOAT WEB, 206L/407

#65292

RELEASED
05.08.12

SECTION B-B

D3283-1
DOUBLER
(REF)

1.970
(REF)

D2792-130
EXTRUSION
(REF)

SECTION A-A

R0.250
(TYP)

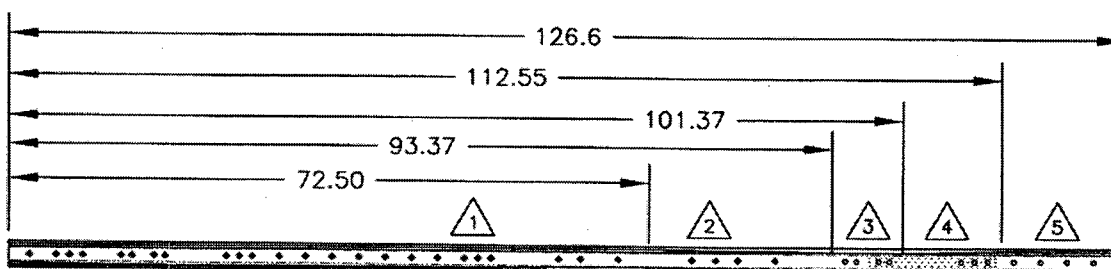
0.05
(TYP)

2.38

D2792-130
EXTRUSION
(REF)

D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
- 5 DRILL #30 (Ø0.128 REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1, SEE DETAIL D FOR REFERENCE
- 6 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS



W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: Float Web		Part Number:	D3282-041
Inspection Dwg: D3282 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	+/-0.100	126.6	—		M-tape	ML-2
1.500	+/-0.010	1.500	—		Vern	ML-7
3.000	+/-0.010	3.000	—		"	"
6.000	+/-0.010	6.000	—		"	"
1.250	+/-0.010	1.250	—		"	"
30.000	+/-0.010	30.000	—		M-tape	ML-2
1.500	+/-0.010	1.500	—		Vern	ML-7
72.01	+/-0.030	72.010	—		M-tape	ML-2
61.75	+/-0.030	61.750	—		"	"
57.50	+/-0.030	57.500	—		"	"
49.19	+/-0.030	49.190	—		"	"
43.94	+/-0.030	43.940	—		"	"
39.69	+/-0.030	39.690	—		"	"
26.68	+/-0.030	26.680	—		"	"
0.55	+/-0.030	.550	—		Vern	ML-7
1.970	+/-0.010	1.971	—		"	"
2.38	+/-0.030	2.378	—		"	"
0.05	+/-0.030	.052	—		"	"

Measured by:	<i>amk</i>	Audited by:	<i>SL</i>	Prototype Approval:	N/A
Date:	11/01/18	Date:	11/01/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	<i>[Signature]</i>